






# Work Order ID 54183

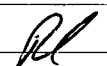


December 2, 2009 11:14:57 AM



Page 1



Item ID: D2948-041 Accept  Setup Start   
 Revision ID: B Stop   
 Item Name: Basket Base, 407  
 Start Date: 02/12/2009 Start Qty: 1.00  Cust Item ID:  
 Required Date: 09/12/2009 Req'd Qty: 1.00  Customer:

## Reference:

Approvals: Process Plan:  Date: 09/12/2 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2948	Rev B

100	 Skidtubes	0.00							
	Skidtubes								
	Skidtubes								
	Memo	0.00							
	Cut (2) D2948-5, 3/4" x 3/4" 120" square tubing for bending as per Dwg D2948								
110	 BENDING MACHINE - SKIDTUBES	0.00							
	CNC Bend 1								
	CNC Delta 100 Bender								
	Memo	0.00							
	Form D2948-5 as per Dwg D2948 using CNC bending program 407BASB and Folio PT019								
120	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
	Quality Control								
	Memo	0.00							

N/A

already done on

10 54256

W 09.12.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54183**

December 2, 2009 11:14:57 AM



Page 2

Item ID: D2948-041  
Revision ID: B  
Item Name: Basket Base, 407

Accept



Setup Start



Stop



Start Date: 02/12/2009 Start Qty: 1.00  
Required Date: 03/12/2009 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Trim to length as per Dwg D2948 and Deburr Identify as D2948-5□2-Cut 3/4"  
x 3/4" square tubing as per Dwg D2948□ Identify properly as D2948-1/-3/-7/-  
9□3-Remove all Markings From Material.□4-Weld as per Dwg D2948 and QSI  
004. Deburr as required. □A/R

SY 09/10/15

PK-7

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

D 09.12.17

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ 8061218



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2948-041 PAR #: \_\_\_\_\_ Fault Category: Large Fab NCR: (Yes) No DQA: J Date: 10-01-07  
 Resolution: Accepted Disposition: use as is QA: N/C Closed: J Date: 10-01-07

NCR: 54183		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/12/10	130	One Rib Found to be made from <del>0.055"</del> 0.055" wall tubing R.C. missed at inspection on c/w 54256. wrong mat. was cut + pulsed. was in with 0.049" wall tubing R.C. LDA	CP 09.12.10 per QSI 042	Acceptable. Adds 0.2 <sup>1/2</sup> in weight	CP 09.12.10 per QSI 042	CP 09.12.10 per QSI 042	CP 09.12.10 per QSI 042	S 09/12/10
			↓					

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54183**

Page 4

December 2, 2009 11:14:57 AM

Item ID: D2948-041  
Revision ID: B  
Item Name: Basket Base, 407

Accept



Setup Start



Stop



Start Date: 02/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06

MF 10-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

December 2, 2009 11:15:04 AM

Page 1

Work Order ID: 54183

Parent Item: D2948-041RevB

Parent Item Name: Basket Base, 407

Comments:

Start Date: 02/12/2009

Required Date: 09/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	348.8932	29.4737			
Expanded Metal Flat SS												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	348.8932065	
110134	3.4	
111630	1.85	
111956	0.000017	
112147	9.4736E-06	
112311	0.9205	
112707	26.6203	
112949	74.31248	
113205	241.7899	

D2327-3RevD

Manufactured No

130 Each 17.0000 1.0000



Spacer Bushing

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	17	
44274	4	
44365	9	
51126	4	

29,4737 09/12/15

1x 09/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 2, 2009 11:15:04 AM

Work Order ID: 54183

Parent Item: D2948-041RevB

Parent Item Name: Basket Base, 407



Start Date: 02/12/2009

Required Date: 09/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1  Mounting Bracket		Manufactured	No			130	Each	24.0000	2.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	12	
46086	2	
48428	1	
51120	9	
Main Warehouse		
WA	12	
50872	1	
51745	11	

D2954RevA



Mounting Plate

Manufactured No

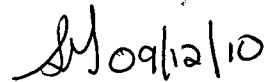
130

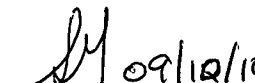
Each

9.0000

4.0000  


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9	
12525	3	
40849	6	

2x  09/12/10

3x  
1x  09/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 2, 2009 11:15:04 AM

Work Order ID: 54183



Parent Item: D2948-041RevB



Parent Item Name: Basket Base, 407

Start Date: 02/12/2009

Required Date: 09/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304TS0.750W.049

Purchased

No

130

f

132.2565

49.1221



304 SQ Tube .75x.75x.049W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

132.2565

103240

10

106604

4.9307

107460

29.2779

109087

88.0479



END BAR  
SCRAP

1" fed

49.1221

09/12/10

D2948-041 x 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

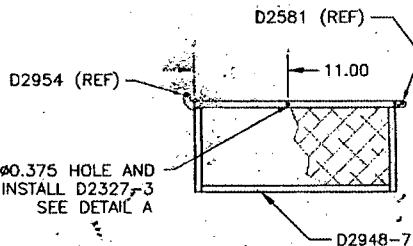
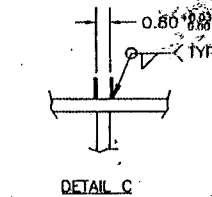
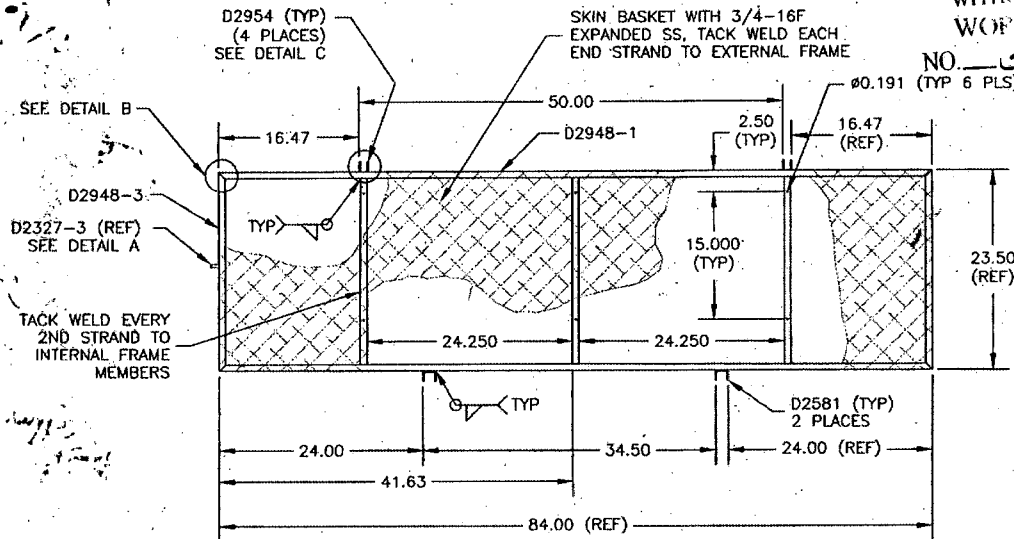
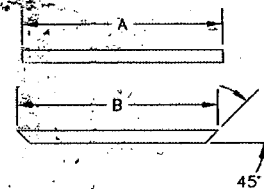
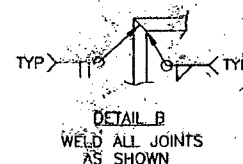
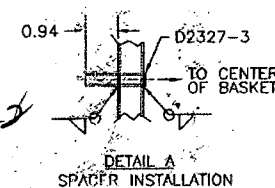
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED

SHO  
REG  
ENC  
UNCONTR  
SUBJECT  
WITH  
WOF

NO. 54183  
R109122



DRILL  $\phi 0.375$  HOLE AND  
INSTALL D2327-3  
SEE DETAIL A

QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
1	D2948-041	BASKET ASSEMBLY	N/A	N/A
2	D2948-1	FRAME MEMBER	N/A	84.00
2	D2948-3	FRAME MEMBER	N/A	23.50
2	D2948-5	FRAME MEMBER	95.97	N/A
3	D2948-7	FRAME MEMBER	22.00	N/A
4	D2948-9	FRAME MEMBER	9.25	N/A
1	D2327-3	SPACER	N/A	N/A
2	D2581	MTG BRACKET	N/A	N/A
4	D2954	MOUNTING PLATE	N/A	N/A

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.049 WALL SQUARE TUBING  
MESH MATERIAL: 3/4-16F EXPANDED SS  
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3  
WELD PER DART QSI 004  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT © 2000 BY DART AEROSPACE LTD.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

B	00.07.17	ADD $\phi 0.191$ ; R7.8 WAS R6.8
A	00.01.12	NEW ISSUE
DESIGN	RF	DRAWN BY
CHECKED	RF	APPROVED
DATE	00.07.17	TITLE
		BASKET BASE ASSEMBLY
		DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, UK
		DRAWING NO. D2948
		REV. B
		SHEET 1 OF 1
		SCALE
		NTS

